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INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<p>(51) International Patent Classification <sup>5</sup> : C10M 173/02 // (C10M 173/02 C10M 129:38, 133:06, 133:06 C10M 133:08, 135:10, 135:10 C10M 145:36) C10N 40:00</p>	<p>A1</p>	<p>(11) International Publication Number: <b>WO 92/13049</b></p> <p>(43) International Publication Date: 6 August 1992 (06.08.92)</p>
<p>(21) International Application Number: PCT/US91/06997</p> <p>(22) International Filing Date: 25 September 1991 (25.09.91)</p> <p>(30) Priority data: 642,065 16 January 1991 (16.01.91) US</p> <p>(71) Applicant: ECOLAB INC. [US/US]; Ecolab Center, Saint Paul, MN 55102 (US).</p> <p>(72) Inventor: GUTZMANN, Timothy, Allen ; 1304 Kolstad Lane, Eagan, MN 55123 (US).</p> <p>(74) Agents: BYRNE, Linda, M. et al.; Merchant, Gould, Smith, Edell, Welter &amp; Schmidt, 1000 Norwest Center, 55 East Fifth Street, Saint Paul, MN 55101 (US).</p>	<p>(81) Designated States: AT (European patent), AU, BE (European patent), CA, CH (European patent), DE (European patent), DK, DK (European patent), ES (European patent), FI, FR (European patent), GB (European patent), GR (European patent), IT (European patent), JP, LU (European patent), NL (European patent), NO, SE (European patent).</p> <p><b>Published</b> <i>With international search report.</i></p>	
<p>(54) Title: CONVEYER LUBRICANT COMPATIBLE WITH SYNTHETIC PLASTIC CONTAINERS</p> <p>(57) Abstract</p> <p>Concentrated liquid and solid lubricating compositions having superior compatibility with synthetic polymeric packaging materials, such as polyethylene terephthalate (PET), linear high density polyethylene (LHDPE), polystyrene, polymeric coated papers, and the like, can include 1 to 50 wt% of a fatty acid diamine salt having the formula <math>[(R^1)(R^2)N(R^3)NH(R^3)(R^4)]^+ (R^6COO)^-</math> or <math>[(R^1)(R^2)NH(R^3)NH(R^3)(R^4)]^+ (R^6COO)_2^-</math> wherein <math>R^1</math> is a <math>C_{10-18}</math> aliphatic group; <math>R^2</math>, <math>R^3</math>, and <math>R^4</math> are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; <math>R^5</math> is a <math>C_{1-5}</math> alkylene group; and <math>R^6</math> is a <math>C_{10-18}</math> aliphatic group. The lubricating compositions are particularly useful on the load bearing surfaces of conveyor belts used in the bottling of carbonated beverages in polyethylene terephthalate bottles.</p> <p style="text-align: center; margin-top: 200px;"><b>BEST AVAILABLE COPY</b></p>		

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**CONVEYOR LUBRICANT COMPATIBLE  
WITH SYNTHETIC PLASTIC CONTAINERS**

## Field of the Invention

Broadly, the invention relates to aqueous lubricant compositions and more particularly to a lubricant compositions compatible with synthetic polymeric packaging materials, such as polyethylene terephthalate (PET), linear high density polyethylene (LHDPE), polystyrene, and the like. Such lubricant compositions are adapted for use as a lubricating agent on the load bearing surfaces of a chain driven conveyor system used for conveying such synthetic polymeric materials. More specifically, the invention relates to a lubricant compositions specifically adapted for use in lubricating the load bearing surface of a conveyor system used in the bottling of carbonated beverages in polyethylene terephthalate bottles.

## Background of the Invention

Beverages and other comestibles are often processed and packaged in synthetic polymeric packaging on mechanized conveyor systems which are lubricated to reduce friction between the packaging and the load bearing surface of the conveyor. The lubricants commonly used on the load bearing surfaces of these conveyor systems, such as those used in the food processing, beverage and the brewery industries, typically contain fatty acid soaps as the active lubricating ingredient because of the superior lubricity provided by fatty acid soaps.

The fatty acid soaps are generally formed by neutralizing a fatty acid with a caustic compound such as alkali metal hydroxide (NaOH or KOH) or an alkanolamine (MEA, DEA or TEA). Fatty acid soaps neutralized with such caustic compounds are generally incompatible with

polyethylene terephthalate to such an extent that prolonged contact frequently results in the formation of stress cracks and fissures in the plastic. This is most frequently observed in bottling plants where carbonated beverages are placed into polyethylene terephthalate bottles because of the stress placed upon the bottle by the bottling process, the carbonated beverage contained within the bottle, and interval pressure.

Various polyethylene terephthalate compatible lubricant compositions have been developed by replacing at least a portion of the fatty acid with other lubricating components. For example, Rossio, United States Patent Number 4,929,375, suggests that incorporation of a tertiary amine, such as a (C<sub>8-10</sub>) alkyl dimethyl amine, into a fatty acid lubricant composition enhances the polyethylene terephthalate compatibility of the lubricant composition.

While these various attempts have been successful in producing lubricant compositions which are compatible with polyethylene terephthalate, such compositions have not generally been effective for providing both superior lubricity and superior compatibility with synthetic polymeric packaging materials. Accordingly, a substantial need still exists for a conveyor lubricant which provides a combination of superior lubricity and compatibility with synthetic polymeric packaging materials.

#### Summary of the Invention

The invention resides in an aqueous lubricant composition capable of providing superior lubricity to the interface between the load bearing surface of a conveyor system and a synthetic polymeric packaging material and a related method for effecting such lubrication. The lubricant composition may be formed as a liquid or solid concentrate and includes an effective lubricating amount of a fatty acid diamine salt having the formula

$[(R^1)(R^2)N(R^5)NH(R^3)(R^4)]^+(R^6COO)^-$  or  
 $[(R^1)(R^2)NH(R^5)NH(R^3)(R^4)]^{++}(R^6COO)_2^-$  wherein  $R^1$  is a  $C_{10-18}$   
 aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen  
 or an alkoxy group containing one to five alkylene oxide  
 5 units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$   
 aliphatic group. The lubricant composition further  
 includes one or more of (i) an amount of a hydrotrope  
 effective for providing sufficient aqueous solubility to  
 the fatty acid and diamine components of the fatty acid  
 10 diamine salt so as to permit formation of the fatty acid  
 diamine salt, (ii) an effective cleansing amount of an  
 anionic or nonionic surfactant, and (iii) an effective  
 chelating amount of a chelating agent. The liquid form of  
 the lubricant composition includes a major proportion of  
 15 water while the solid form of the lubricant composition  
 includes an amount of a solidification agent effective for  
 assisting in solidification of the composition.

#### Detailed Description of the Invention

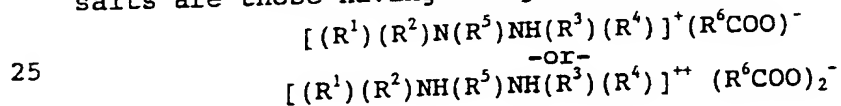
20 The invention resides in an improved lubricant  
 concentrate composition that can be formulated in liquid or  
 solid form. The lubricant composition comprises (-) a  
 fatty acid diamine salt having the formula  
 $[(R^1)(R^2)N(R^5)NH(R^3)(R^4)]^+(R^6COO)^-$  or  
 25  $[(R^1)(R^2)NH(R^5)NH(R^3)(R^4)]^{++}(R^6COO)_2^-$  wherein  $R^1$  is a  $C_{10-18}$   
 aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen  
 or an alkoxy (preferably ethoxy) group containing one to  
 five alkylene oxide (preferably ethylene oxide) units;  $R^5$   
 is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group,  
 30 (-) a hydrotrope effective for providing sufficient aqueous  
 solubility to the fatty acid and diamine components of the  
 fatty acid diamine salt so as to permit formation of the  
 fatty acid diamine salt, (-) an anionic or nonionic  
 surfactant effective for cleaning the lubricated surface,  
 35 and (-) a chelating agent. The liquid form of the

lubricant composition further includes a major proportion of water while the solid form of the lubricant composition further includes an amount of a solidification agent effective for assisting in solidification of the composition.

The lubricant composition may also include various optional components intended to enhance lubricity, microbial efficacy, physical and/or chemical stability, etc. The lubricant composition of the invention is particularly well suited for lubricating the load bearing surfaces and drive chains of conveyor systems used to convey polyethylene terephthalate bottles filled with a carbonated beverage.

#### 15 Fatty Acid Diamine Salt

We have surprisingly discovered that an aqueous solution of selected fatty acid diamine salts obtained as the neutralization product of a fatty acid and a diamine performs as an effective polyethylene terephthalate compatible lubricant composition capable of providing effective lubricating properties to the load bearing surface of a conveyor system. Useful fatty acid diamine salts are those having the general formula:



wherein: (-)  $R^1$  is a  $C_{10-18}$  aliphatic group,

(-)  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units,

(-)  $R^5$  is a  $C_{1-5}$  alkylene group, and

(-)  $R^6$  is a  $C_{10-18}$  aliphatic group.

For reasons of performance the preferred fatty acid diamine salts are those wherein  $R^1$  is a  $C_{10-18}$  aliphatic group derived from a fatty acid;  $R^4$  is hydrogen;  $R^5$  is a  $C_{2-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group.

5 For reasons of availability and performance the most preferred fatty acid diamine salts are those wherein  $R^1$  is a  $C_{10-18}$  aliphatic group derived from a fatty acid;  $R^2$ ,  $R^3$ , and  $R^4$  are hydrogen;  $R^5$  is a propylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group.

10 The fatty acid diamine salts may be conveniently produced by reacting a suitable diamine of the formula  $(R^1)(R^2)N(R^5)N(R^3)(R^4)$  with a suitable fatty acid of the formula  $R^6COOH$  under conditions sufficient to produce the fatty acid diamine salt. Generally, such fatty acids will  
15 spontaneously neutralize such diamines to form the fatty acid diamine salts under ambient conditions provided both components can be brought into intimate contact such as through mutual solubilization.

The fatty acid diamine salt in liquid concentrates can  
20 be formed in solution by adding the hydrotrope to the water and then sequentially adding the fatty acid and the diamine. The fatty acid and diamine will react spontaneously to form the fatty acid diamine salt. The remaining formula components such as surfactant(s),  
25 sequestrant(s), alcohol(s) and other components can then be

added and mixed into the formulation to complete the concentrate.

The fatty acid diamine salt in solid concentrates can be formed by (i) combining the hydrotrope, surfactant(s), sequestrant(s), and alcohol(s) to form a liquid premix, (ii) adding the fatty acid(s) to the premix to form a first mixture, (iii) heating the first mixture to a temperature above the melting point of the solidifying agent, (iv) sequentially adding the solidifying agent and the diamine to the heated first mixture under constant agitation to form a second mixture, (v) allowing the fatty acid and the diamine to spontaneously react in the second mixture to form a fatty acid diamine salt, and (vi) allowing the second mixture to solidify into a water soluble block of lubricant by cessation of agitation and cooling to ambient temperatures.

#### *Diamines*

Useful diamines are those having the general formula:



wherein: (-)  $R^1$  is a  $C_{10-18}$  aliphatic group, preferably derived from a  $C_{10-18}$  fatty acid,  
(-)  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units, preferably hydrogen, and



(-)  $R^5$  is a  $C_{1-5}$  alkylene group, preferably a propylene group.

Representative examples of useful diamines include N-coco-1,3-propylene diamine (N-coco-1,3 diaminopropane), N-  
5 oleyl-1,3-propylene diamine (N-oleyl-1,3 diaminopropane), N-tallow-1,3-propylene diamine (N-tallow-1,3 diaminopropane), and mixtures thereof. Such N-alkyl-1,3 diaminopropanes are available from Akzo Chemie America, Armak Chemicals under the trademark Duomeen®.

10

#### *Fatty Acids*

A wide variety of fatty acids may be usefully employed in the lubricant compositions of the invention. Those acids found to provide effective lubricity are those having  
15 the general formula  $R^6COOH$  wherein  $R^6$  represents an aliphatic group having from about 9 to about 17 carbon atoms so as to produce a fatty acid having about 10 to 18 carbon atoms. For use in formulating the solid form of the composition the  $C_{16-18}$  fatty acids are preferred as they  
20 assist in solidification of the composition. The aliphatic group may be branched or unbranched and saturated or unsaturated but is preferably a straight chain alkyl group.

Specific examples of suitable fatty acids include such saturated fatty acids as capric (decanoic) ( $C_{10}$ ),  
25 undecylic (undecanoic) ( $C_{11}$ ), lauric (dodecanoic) ( $C_{12}$ ), trideclic (tridecanoic) ( $C_{13}$ ), myristic (tetradecanoic)

(C<sub>14</sub>), palmitic (hexadecanoic) (C<sub>16</sub>), stearic (octadecanoic) (C<sub>18</sub>); monounsaturated fatty acids such as lauroleic (C<sub>12</sub>), myristoleic (C<sub>14</sub>), palmitoleic (C<sub>16</sub>), and oleic (C<sub>18</sub>); polyunsaturated fatty acids such as linoleic (di-unsaturated C<sub>18</sub>), and linolenic (tri-unsaturated C<sub>18</sub>); and substituted fatty acids such as ricinoleic (hydroxy-substituted C<sub>18</sub>).

Mixed fatty acids may be employed in the lubricant composition of the invention such as those derived from fats and oils. Coconut oil fatty acids are particularly preferred in the lubricant compositions of the invention because of their ready availability and superior lubricating properties. Coconut oil fatty acids include major fractions of lauric and myristic acids and minor fractions of palmitic, stearic, oleic and linoleic acids. Tall oil fatty acids, obtained as a byproduct of the paper industry from the tall oil recovered from pine wood black liquor, are also preferred fatty acids for use in the lubricant composition of the invention. Tall oil fatty acids include major fractions of oleic and linoleic acids and minor fractions of palmitic, stearic, and isostearic acids.

### Other Components

#### *Water*

When the lubricant composition of the invention is formulated as a liquid the composition includes a major portion of water in addition to the fatty acid diamine salt.

#### *Solidifying Agent*

When the lubricant composition of the invention is formulated as a solid the composition optionally, but preferably, includes an effective solidifying proportion of a solidifying agent. Any compound which is compatible with the other components of the lubricant composition and is capable of aiding in solidification of the composition may be employed. Suitable solidification agents include higher molecular weight glycols, polyalkylene glycols such as polyethylene glycol (PEG), higher molecular weight fatty acid soaps, and urea. The fatty acid soaps may be conveniently formed in situ by adding sodium or potassium hydroxide to the composition so as to convert a portion of the fatty acid to the corresponding alkali metal fatty acid soap (See Trial #s 11 and 12).

#### *Hydrotrope*

The lubricant composition of the invention includes an effective amount of a hydrotrope for effecting aqueous

solubilization of the fatty acid and the diamine. Such mutual aqueous solubilization is necessary for achieving substantially complete neutralization of the fatty acid by the diamine and for phase stability of the dilute use solution of the lubricant composition. A variety of compatible hydrotropes are available for use in the lubricant composition. For reasons of overall compatibility with the other components and effectiveness for solubilizing the fatty acid and diamine, the preferred hydrotropes are the anionic surfactant sulfonates. A non-exhaustive list of suitable sulfonates includes specifically, but not exclusively, alkali metal salts of C<sub>6-18</sub> alkyl sulfonates such as sodium decane sulfonate and sodium dodecane sulfonate, alkali metal aryl sulfonates such as sodium benzene sulfonate and sodium phenol sulfonate, and C<sub>6-30</sub> alkaryl sulfonates such as sodium C<sub>2-18</sub> alkyl naphthalene sulfonate and sodium xylene sulfonate.

Hydrotropes which are solid under ambient conditions may be usefully employed when formulating the solid form of the lubricant compositions of the invention as such solid hydrotropes assist in solidification of the composition. Suitable solid hydrotropes for use in the lubricant compositions of the invention includes specifically, but not exclusively, C<sub>2-18</sub> alkyl naphthalene sulfonates available from PetroChemicals Company, Inc. under the mark "Petro".

The proportion of hydrotrope which should be employed depends upon various factors including the specific hydrotrope employed and the specific fatty acid and diamine employed. However, effective results can generally be  
5 obtained by including about 2-40 wt% hydrotrope, preferably about 5-20 wt%, in the lubricant composition.

#### Surfactants

The lubricant compositions of the invention optionally,  
10 but preferably, may further include a compatible material for enhancing the lubricity of the composition, such as an anionic or nonionic surfactant.

Anionic surfactants are generally those compounds containing a hydrophobic hydrocarbon moiety and a  
15 negatively charged hydrophilic moiety. Typical commercially available products provide either a carboxylate, sulfonate, sulfate or phosphate group as the negatively charged hydrophilic moiety. Broadly, any of the commercially available anionic surfactants may be usefully  
20 employed in the lubricant composition of the invention.

Particularly suitable anionic surfactants for use in the lubricant composition of the invention are the sulfonates having the general formula  $(R^{30})SO_3Na$  wherein  $R^{30}$  is a hydrocarbon group in the surfactant molecular-weight  
25 range. For reasons of cost, availability and overall compatibility with the other components of the lubricant

composition, the preferred anionic surfactants for use in the lubricant composition are the alkaryl sulfonates such as alkyl benzene sulfonates and alkyl naphthalene sulfonates.

5 Nonionic surfactants are generally hydrophobic compounds which bear essentially no charge and exhibit a hydrophilic tendency due to the presence of oxygen in the molecule. Nonionic surfactants encompass a wide variety of polymeric compounds which include specifically, but not  
10 exclusively, ethoxylated alkylphenols, ethoxylated aliphatic alcohols, ethoxylated amines, carboxylic esters, carboxylic amides, and polyoxyalkylene oxide block copolymers.

Particularly suitable nonionic surfactants for use in  
15 the lubricant composition of the invention are the alkoxyated (preferably ethoxylated) alcohols having the general formula  $R^{10}O((CH_2)_mO)_n$  wherein  $R^{10}$  is an aliphatic group having from about 8 to about 24 carbon atoms, m is a whole number from 1 to about 5, and n is a number from 1 to  
20 about 20 which represents the average number of ethyleneoxide groups on the molecule.

Based upon their overall compatibility with the other components of the lubricant composition and their ability to enhance the lubricity and cleansing effect of the  
25 lubricant composition at a reasonable cost, a particularly preferred group of nonionic surfactants are the alkoxyated

amines having the general formula  $(R^{21})(R^{22})(R^{23})N$  wherein  $R^{21}$ ,  $R^{22}$ , and  $R^{23}$  are independently hydrogen, a  $C_{1-5}$  alkyl, or a polyalkoxy (preferably polyethoxy) group having the general formula  $((CH_2)_mO)_n$  wherein  $m$  is a number from 2 to 4 and  $n$  is a number from 1 to about 20 with at least one of  $R^{21}$ ,  $R^{22}$ , and  $R^{23}$  being a polyalkoxy group.

#### Sequestrant

The compositions of the invention may also optionally contain a sequestrant for the purpose of complexing or chelating hardness components in the service water into which the lubricant composition is dispensed. Sequestrants are reagents that combine with metal ions to produce soluble complexes or chelate compounds. The most common and widely used sequestrants are those that coordinate metal ions through oxygen and/or nitrogen donor atoms. The sequestrant use in the lubricant composition of the invention may be organic or inorganic so long as it is compatible with the other components of the composition. Based upon availability and overall compatibility with the other components, the preferred sequestrant is ethylenediamine tetraacetic acid.

#### Alcohol

The novel lubricant compositions of the invention may also contain a  $(C_{1-10})$  alcohol having about 1-5 hydroxy

groups for the purpose of enhancing the physical stability, wettability, and activity of the composition. A nonexhaustive list of suitable alcohols include methanol, ethanol, isopropanol, t-butanol, ethylene glycol, propylene glycol, hexylene glycol, glycerine, low molecular weight polyethylene glycol compounds, and the like.

#### *Other Components*

In addition to the above mentioned components, the lubricating compositions of the invention may also contain those components conventionally employed in conveyor lubricant compositions, which are compatible in the composition, to achieve specified characteristics such as anti-foam additives, viscosity control agents, perfumes, dyes, corrosion protection agents, etc.

#### *Concentrations*

Broadly, the solid and liquid forms of the concentrated lubricant compositions of the invention should include about 1-70 wt% of the fatty acid diamine salt. More specifically, the liquid form should include about 1-50 wt% fatty acid diamine salt and the solid concentrate about 5-70 wt% fatty acid diamine salt.

A preferred liquid concentrate of the lubricant composition of the invention includes about 5-25 wt% fatty acid diamine salt made from about 4-20 wt% fatty acid and



1-10 wt% diamine. The liquid concentrate can also include about 2-40 wt% hydrotrope, about 2-30 wt% surfactant, and about 1-20 wt% sequestrant.

A preferred solid concentrate of the lubricant composition of the invention includes about 10-60 wt% fatty acid diamine salt made from about 8-50 wt% fatty acid and about 2-20 wt% diamine. The solid concentrate can also include about 2-40 wt% hydrotrope, about 2-30 wt% surfactant, and about 1-20 wt% sequestrant.

10 The lubricant compositions of the invention may be applied to the load bearing surface of a conveyor system by any of the recognized methods for such application including the most commonly utilized and widely accepted practice of spraying the lubricant onto the moving conveyor surface. However, prior dispensing the lubricant compositions of the invention onto the moving conveyor, the composition must be diluted with water to use strength. The diluted lubricant use solution should contain about 50 to 20,000 ppm (wt/v), preferably about 100 to 10,000 ppm (wt/v), active lubricant components wherein the active components of the lubricant composition includes all those components which contribute to the lubricating efficacy of the composition, specifically excluding any water contained in the composition. More specifically, the diluted lubricant use solution should contain about 50 to 10,000 ppm (wt/v), preferably about 100 to 5,000 ppm (wt/v) fatty

acid diamine salt, about 50 to 8,000 ppm (wt/v) hydrotrope, about 0 to 6,000 ppm (wt/v) surfactant, and about 0 to 5,000 ppm (wt/v) sequestrant.

This description is provided to aid in a complete  
5 nonlimiting understanding of the invention. Since many variations of the invention may be made without departing from the spirit and scope of the invention, the breadth of the invention resides in the claims hereinafter appended.

Table One  
Liquid Formulations  
(wt%)

#	Amines				Fatty Acids			Sulfonates					Neo	Water
	DuoCD	C <sub>12</sub> PA	K202	K210	K215	Oleic	Coco	Tall	Petro	NOS	SXS	V100		
1	-	5.9	-	-	-	6.0	6.0	-	40.0	-	-	10.0	-	32.1
2	-	-	9.0	-	-	6.0	6.0	-	40.0	-	-	10.0	-	29.0
3	4.0	-	-	-	-	6.0	6.0	-	40.0	-	-	10.0	-	34.0
4	4.0	-	-	-	-	6.0	6.0	-	50.0	-	-	10.0	-	24.0
5	4.0	-	-	-	-	6.0	6.0	-	50.0	-	-	10.0	2.0	22.0
6	3.2	-	-	5.0	-	5.0	5.0	-	40.0	-	-	10.0	-	31.8
7	2.5	-	-	5.0	-	5.0	5.0	-	40.0	-	-	10.0	-	32.5
8	1.5	-	-	-	15.0	-	-	12.0	-	40.0	-	10.0	-	21.5
9	1.5	-	-	-	15.0	-	-	12.0	-	-	40.0	10.0	-	21.5

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Table Two  
Solid Formulations  
(wt%)

#	Amines			Fatty Acids				Sulfonates						PEG	
	DuoCD	T-20	K215	Oleic	Coco	Tall	NaOH	Petro	NOS	SXS	V100	X3176	DF210		Urea
10	4.0	-	-	5.0	5.0	-	-	40.0	26.0	-	10.0	10.0	-	-	-
11	3.0	-	21.9	-	-	23.8	6.8	39.6	-	-	4.0 <sup>a</sup>	-	1.0	-	-
12	3.0	-	24.0	-	10.0	14.0	4.0	40.0 <sup>b</sup>	-	-	4.0 <sup>a</sup>	-	1.0	-	-
13	5.0	-	10.0	10.0	10.0	-	-	40.0 <sup>b</sup>	-	-	4.0	-	-	15.0	-
14	3.0	-	19.0	-	-	20.0	-	38.0 <sup>c</sup>	-	-	4.0	-	1.0	15.0	-
15	-	27.7	-	-	-	19.8	-	29.7 <sup>d</sup>	-	-	4.0	-	1.0	-	17.8
16	-	28.0	-	-	-	20.0	-	-	-	20.0 <sup>e</sup>	3.0	-	1.0	-	28.0

- <sup>a</sup> - Versene 220<sup>®</sup> used in place of Versene 100<sup>®</sup>.  
<sup>b</sup> - Added as 16 wt% LBA liquid and 30 wt% BA powder.  
<sup>c</sup> - Added as 8 wt% LBA liquid and 30 wt% BA powder.  
<sup>d</sup> - Added as BA powder.  
<sup>e</sup> - Added as a 90 wt% active powder.

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Table Three  
Formulation Comments

<u>Formula #</u>	<u>Comments</u>
1	Liquid concentrate contained curds. Incorporation of additional Petro LBA <sup>®</sup> reduced amount of curdling but did not completely eliminate. A 1 wt% use solution of the composition had a pH of 8.86.
2	Liquid concentrate. A 1 wt% use solution of the composition had a pH of 8.68 and was slightly hazy.
3	Liquid concentrate. A 1 wt% use solution of the composition had a pH of 8.98 and was slightly hazy.
4	Liquid concentrate.
5	Liquid concentrate. A 1 wt% use solution of the composition had a pH of 8.85.
6	Liquid concentrate. A 1 wt% use solution of the composition had a pH of 9.40.
7	Liquid concentrate. A 1 wt% use solution of the composition had a pH of 9.08.
8	Liquid concentrate. The concentrated composition was clear. A 1 wt% use solution of the composition had a pH of 7.84.
9	The liquid concentrate was clear and remained stable at 40°F. A 1 wt% use solution of the composition had a pH of 8.94.
10	Solid concentrate. A 1 wt% use solution of the composition had a pH of 8.13 and was clear.
11	The concentrate was solid but slightly tacky. A 0.5 wt% use solution of the composition had a pH of 10.99.
12	The mixture was fluid at 190-200°F and solidified quickly upon cooling. The concentrate was solid but slightly tacky. The solid concentrate was easily removed from the mold. A 0.5 wt% use solution of the

composition had a pH of 9.86.

13 The mixture gelled during mixing but thinned when heated slightly. The concentrate was solid but tacky. The solid concentrate would not release from the mold.

14 Solid concentrate. A use solution of the composition was turbid.

15 The solid concentrate was a soft, slightly tacky composition. A 0.5 wt% use solution of the composition was clear. A 0.5 wt% use solution of the composition had a pH of 8.68.

16 The concentrate was a soft solid. A use solution of the composition was opaque.

## Nomenclature\*

- DuoCD = Duomeen CD<sup>®</sup> (N-coco-1,3-[propane] diamine) available from Akzo Chemie America, Armak Chemicals.
- C<sub>12</sub>PA = A dodecyl amine available from Akzo Chemie America, Armak Chemicals.
- K202 = Varonic K202<sup>®</sup> (a C<sub>10-18</sub> alkyl amine ethoxylate having an average of about 2 moles of ethyleneoxide per molecule available from Sherex Chemical Co. Inc.
- K210 = Varonic K210<sup>®</sup> (a C<sub>10-18</sub> alkyl amine ethoxylate having an average of about 10 moles of ethyleneoxide per molecule available from Sherex Chemical Co. Inc.
- K215 = Varonic K210<sup>®</sup> (C<sub>10-18</sub> alkyl amine ethoxylates) having an average of about 15 moles of ethyleneoxide per molecule available from Sherex Chemical Co. Inc.
- Oleic = Oleic oil fatty acids. A mixture of C<sub>10-18</sub> fatty acids containing primarily C<sub>18</sub> fatty acids.
- Coco = Coconut oil fatty acids. A mixture of C<sub>12-18</sub> saturated and unsaturated fatty acids containing primarily C<sub>12</sub> and C<sub>14</sub> saturated fatty acids.
- Tall = Tall oil fatty acids. A mixture of C<sub>16-18</sub> saturated and unsaturated fatty acids containing primarily monounsaturated and diunsaturated C<sub>18</sub> fatty acids.
- Petro = Petro LBA<sup>®</sup> (C<sub>2-18</sub> alkyl naphthalene sulphonates) available from PetroChemical Co. Inc. Petro BA<sup>®</sup> is a dark colored form of Petro LBA<sup>®</sup>.
- NOS = n-octyl sulphonate.
- SXS = Aqueous solution of 40 wt% sodium xylene sulphonate.
- V100 = Versene 100<sup>®</sup> (aqueous solution containing 40 wt% tetrasodium EDTA) available from Dow Chemical Company.
- V220 = Versene 220<sup>®</sup> (powdered tetrasodium EDTA) available from Dow Chemical Company.
- Neo = Neodol<sup>®</sup> (C<sub>14-15</sub> alcohol ethoxylates having an average of 12 to 14 moles ethyleneoxide per molecule) available from Shell.
- X3176 = Desomeen X-3176<sup>®</sup> (proprietary cationic surfactants) available from Desoto Chemical Company.

- DF210 = Mazu DF210® (a silicone defoamer containing 10% active components) available from Mazer Chemical.
- T-20 = Ethoduomeen T/20® (an ethoxylated N-tallow-1,3-diaminopropane containing an average of 10 ethoxy units) available from Akzo Chemie America, Arma Chemicals.
- PEG = Polyethylene glycol having an average molecular weight of about 8000 available from Union Carbide Corp.

\* All are 100% active unless otherwise specified.



**Polyethylene Terephthalate  
Bottle Stress Crack Testing Procedure**

The test is designed to comparatively determine the affect of conveyor lubricating compositions on pressurized polyethylene terephthalate (PET) bottles.

Fill twenty-four two liter polyethylene terephthalate test bottles with carbonated city water, using a McCann carbonator equipped with a Procon pump, to 5.0 to 5.2 volumes of CO<sub>2</sub> as determined by a Zahm-Nagel CO<sub>2</sub> Tester. Test every sixth bottle during filling for CO<sub>2</sub> loading. If the tested bottle is below 5.0 volumes CO<sub>2</sub> discard tested and previous five bottles. Allow the filled bottles to set at room temperature overnight.

Dilute the two concentrated conveyor lubricant compositions to be tested with distilled water at a lubricant:water ratio of 1:60 (1.67%) for the liquid concentrated lubricants and 1:200 (0.50%) for the solid concentrated lubricants.

Separately place 200 mls of each of the dilute lubricant solutions into a mixing bowl and whip with a Kitchen Aid K-5A Mixer equipped with a wire whip attachment at a speed setting of ten for five minutes in order to foam the solution.

Separately rinse a 13.5" by 18.5" (inside diameter) polyethylene storage bin with 100 mls of the dilute lubricant

solutions (unfoamed). Drain the rinsed bins thoroughly and place 75.0 grams of each of the foamed lubricant solutions into separate storage bins.

Place twelve of the filled bottles into each of the polyethylene bins making sure all bottle bottoms are thoroughly coated with the foamed lubricant solution. Allow the filled bottles to set for four to five hours under room conditions.

Set the filled bottles while still in the polyethylene bins in a temperature/humidity control room set at a temperature of  $100^{\circ}\text{F} \pm 5^{\circ}\text{F}$  and a humidity of 85% Relative Humidity  $\pm 5\%$ . Monitor the bottles daily for any leakage for fourteen days. After completion of testing period, compare crack formation on bottles treated with the two different lubricant compositions.

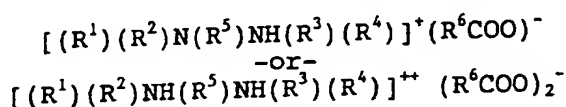
**Polyethylene Terephthalate  
Compatability Testing**

Polyethylene terephthalate compatability testing was conducted for Formulations #4, #5, #7 and #10 in accordance with the "Bottle Stress Crack Testing Procedure" set forth above. In addition, commercially available conveyor lubricants employing ethoxylated amines (DicoLube PL™) and alkyl dimethyl amines as described in United States Patent No. 4,929,375 as the active lubricant were tested for polyethylene terephthalate compatability. All formulations and commercially available products resulted in zero leakage. However, based upon comparision testing of crack formation, the polyethylene terephthalate compatability of those lubricants based upon the diamines (The Invention) were observed to be superior to those based upon ethoxylated amines (DicoLube PL™) and those based upon alkyl dimethyl amines as described in United States Patent No. 4,929,375.

We claim:

1. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

5 (-) an effective lubricating amount of a fatty acid diamine salt having the formula



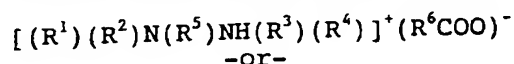
10 wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group;

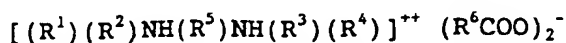
15 (-) an amount of a hydrotrope effective for providing sufficient aqueous solubility to the fatty acid and diamine components of the fatty acid diamine salt so as to permit formation of the fatty acid diamine salt, and

20 (-) a balance of water.

2. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

25 (-) an effective lubricating amount of a fatty acid diamine salt having the formula





wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group;

(-) an effective cleansing amount of an anionic or nonionic surfactant, and

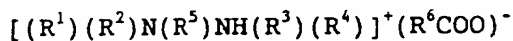
(-) a balance of water.

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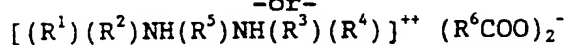
3. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

(-) an effective lubricating amount of a fatty acid diamine salt having the formula

15



-or-



wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group;

20

(-) an effective chelating amount of a chelating agent, and

25

(-) a balance of water.

4. The concentrate of claim 1 wherein  $R^1$  is derived from a  $C_{10-18}$  fatty acid.

5. The concentrate of claim 1 wherein  $R^5$  is a propylene group.

6. The concentrate of claim 1 wherein the diamine portion of the diamine fatty acid salt is a  $N-(C_{10-18})$  aliphatic-1,3-propylene diamine.

10

7. The concentrate of claim 1 wherein the hydrotrope is an alkali metal sulphonate selected from the group consisting of alkali metal  $C_{6-18}$  alkyl sulfonates and alkali metal  $C_{6-30}$  alkaryl sulfonates.

15

8. The concentrate of claim 2 wherein the surfactant is selected from the group consisting of a fatty acid soap, a sulfonates, an alkoxyated aliphatic alcohol, an alkoxyated amine, and mixtures thereof.

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9. The concentrate of claim 3 wherein the chelating agent is ethylene diamine tetraacetic acid or a salt thereof.

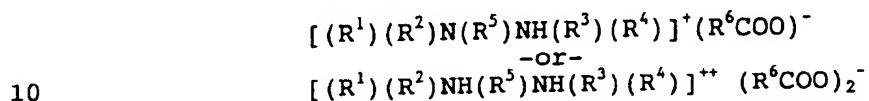
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10. The concentrate of claim 1 wherein the lubricant comprises about 1-50 wt% fatty acid diamine salt.

11. An aqueous liquid concentrate which can form an aqueous lubricant composition for the load bearing surface of a conveyor system upon dilution with water, said

5 concentrate comprising:

(a) about 1-50 wt-% of a fatty acid diamine salt having the formula



wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and

15  $R^6$  is a  $C_{10-18}$  aliphatic group;

(b) about 2-40 wt-% of a hydrotrope selected from the group consisting of an alkali metal  $C_{6-18}$  alkyl sulphonate, an alkali metal  $C_{6-30}$  alkaryl sulphonate, and mixtures thereof;

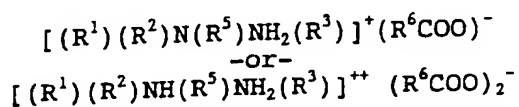
20 (c) about 2-30 wt% of an anionic or nonionic surfactant selected from the group consisting of a fatty acid soap, a sulfonates, an alkoxyated aliphatic alcohol, and an alkoxyated amine;

25 (d) about 1-20 wt% EDTA or a salt thereof; and

(e) the balance water.

12. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

- 5 (-) an effective lubricating amount of the neutralization product of a C<sub>10-18</sub> fatty acid and a diamine having the formula



- 10 wherein R<sup>1</sup> is a C<sub>10-18</sub> aliphatic group; R<sup>2</sup> and R<sup>3</sup> are independently hydrogen or an alkoxy group, containing one to five alkylene oxide units; and R<sup>5</sup> is a C<sub>1-5</sub> alkylene group;

- 15 (-) an amount of a hydrotrope effective for providing sufficient aqueous solubility to the fatty acid and diamine components of the fatty acid diamine salt so as to permit substantially complete neutralization of the diamine by the fatty acid, and

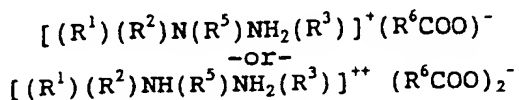
- 20 (-) a balance of water.

13. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

- 25 (-) an effective lubricating amount of the neutralization product of a C<sub>10-18</sub> fatty acid and a diamine having the formula



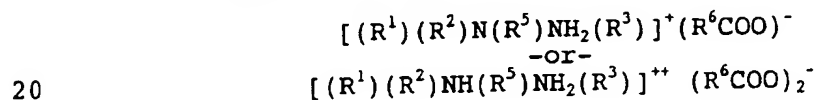
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- 5 wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$  and  $R^3$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; and  $R^5$  is a  $C_{1-5}$  alkylene group;
- (-) an effective cleansing amount of an anionic or nonionic surfactant, and
- 10 (-) a balance of water.

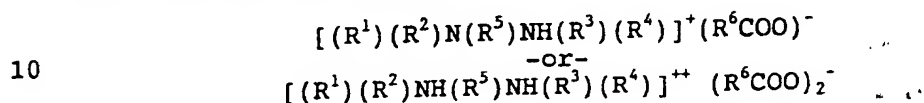
14. An aqueous liquid conveyor lubricant concentrate which is compatible with synthetic polymeric packaging materials, the concentrate comprising:

- 15 (-) an effective lubricating amount of the neutralization product of a  $C_{10-18}$  fatty acid and a diamine having the formula



- wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$  and  $R^3$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; and  $R^5$  is a  $C_{1-5}$  alkylene group;
- 25 (-) an effective chelating amount of a chelating agent, and
- (-) a balance of water.

15. A process for lubricating the load bearing surface of a conveyor system comprising the step of coating the load bearing surface of the conveyor system with a sufficient lubricating amount of a conveyor lubricant comprising at least (-) a major proportion of water, and (-) an effective lubricating amount of a fatty acid diamine salt having the formula



wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group.

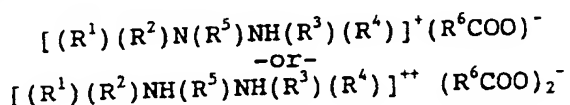
16. The process of claim 15 wherein  $R^1$  is derived from a  $C_{10-18}$  fatty acid and  $R^5$  is a propylene group.

17. A process for lubricating the load bearing surface of a conveyor system comprising the step of coating the load bearing surface of the conveyor system with an effective lubricating amount of a conveyor lubricant comprising at least (-) a major proportion of water, and (-) an effective lubricating amount of the neutralization product of a  $C_{10-18}$  fatty acid and a diamine having the formula  $(R^1)(R^2)N(R^5)NH(R^3)(R^4)$  wherein  $R^1$  is a  $C_{10-18}$

aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; and  $R^5$  is a  $C_{1-5}$  alkylene group.

5 18. A process for lubricating the load bearing surface of a conveyor system comprising the steps of:

(a) dispersing a concentrate of a lubricating composition into sufficient water to form an aqueous lubricating solution, wherein (i) said lubricating concentrate comprises at least an effective lubricating amount of a fatty acid diamine salt having the formula



15 wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units;  $R^5$  is a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic group; and (ii) said lubricating solution comprises at least about 50-10,000 ppm (w/v) of the fatty acid diamine salt; and

20 (b) placing said lubricating solution onto the load bearing surface of an operating conveyor system in an amount and for a period of time effective to lubricate the load bearing surface.

25

19. The process of claim 18 wherein the lubricating solution comprises at least about 100-5,000 ppm (w/v) of

the fatty acid diamine salt.

20. The process of claim 18 wherein  $R^1$  is derived from a  $C_{10-18}$  fatty acid and  $R^5$  is a propylene group.

5

21. A process for lubricating the load bearing surface of a conveyor system comprising the steps of:

(a) dispersing a concentrate of a lubricating composition into sufficient water to form an aqueous lubricating solution, wherein (i) said lubricating concentrate comprises at least an effective lubricating amount of the neutralization product of a  $C_{10-18}$  fatty acid and a diamine having the formula  $(R^1)(R^2)N(R^5)NH(R^3)(R^4)$  wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; and  $R^5$  is a  $C_{1-5}$  alkylene group, and (ii) said lubricating solution comprises at least about 50-5000 ppm (w/v) of the neutralization product; and

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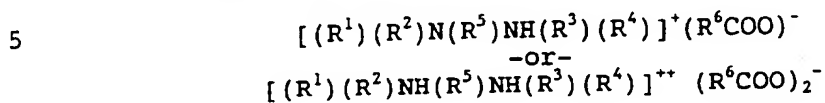
(b) placing said lubricating solution onto the load bearing surface of an operating conveyor system in an amount and for a period of time effective to lubricate the load bearing surface.

25

22. A solid conveyor lubricant concentrate dilutable with an aqueous base to form a use solution which is

compatible with synthetic polymeric packaging materials,  
the concentrate comprising:

(-) an effective lubricating amount of a fatty  
acid diamine salt having the formula



wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  
 $R^4$  are independently hydrogen or an alkoxy group  
containing one to five alkylene oxide units;  $R^5$  is  
a  $C_{1-5}$  alkylene group; and  $R^6$  is a  $C_{10-18}$  aliphatic  
group; and

(-) an amount of a solidification agent effective  
for solidifying the concentrated lubricant.

15

23. The concentrated solid conveyor lubricant of claim  
22 further comprising (-) an effective cleansing amount of  
an anionic or nonionic surfactant, and (-) an effective  
chelating amount of a chelating agent.

20

24. The concentrated solid conveyor lubricant of claim  
22 wherein  $R^1$  is derived from a  $C_{10-18}$  fatty acid and  $R^5$  is a  
propylene group.

25

25. The concentrated solid conveyor lubricant of claim  
22 wherein the diamine portion of the diamine fatty acid  
salt is a  $N-(C_{10-18})$  aliphatic-1,3-propylene diamine.

26. The concentrated solid conveyor lubricant of claim 23 wherein the chelating agent is ethylene diamine tetraacetic acid.

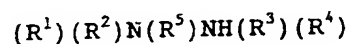
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27. The concentrated solid conveyor lubricant of claim 22 wherein the lubricant comprises about 5-70 wt% of the fatty acid diamine salt.

10 28. A concentrated solid polyethylene terephthalate compatible conveyor lubricant comprising:

(-) an effective lubricating amount of the neutralization product of a  $C_{10-18}$  fatty acid and a diamine having the formula

15



wherein  $R^1$  is a  $C_{10-18}$  aliphatic group;  $R^2$ ,  $R^3$ , and  $R^4$  are independently hydrogen or an alkoxy group containing one to five alkylene oxide units; and  $R^5$  is a  $C_{1-5}$  alkylene group; and

20

(-) an amount of a solidification agent effective for solidifying the concentrated lubricant.

29. The solid concentrated conveyor lubricant of claim 28 further comprising (-) an effective cleansing amount of an anionic or nonionic surfactant, and (-) an effective chelating amount of a chelating agent.

25

30. The solid concentrated conveyor lubricant of claim 28 wherein R<sup>1</sup> is derived from a C<sub>10-18</sub> fatty acid and R<sup>5</sup> is a propylene group.

## INTERNATIONAL SEARCH REPORT

PCT/US 91/06997

International Application No.

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (If several classification symbols apply, indicate all) <sup>6</sup>		
According to International Patent Classification (IPC) or to both National Classification and IPC		
Int.Cl. 5 C10M173/02; //(C10M173/02, 129:38, 133:06, 133:06, 133:08, 135:10, 135:10, 145:36)C10N40:00		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched <sup>7</sup>		
Classification System	Classification Symbols	
Int.Cl. 5	C10M	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched <sup>8</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT<sup>9</sup></b>		
Category <sup>9</sup>	Citation of Document, <sup>11</sup> with indication, where appropriate, of the relevant passages <sup>12</sup>	Relevant to Claim No. <sup>13</sup>
X	WO,A,9 010 053 (HENKEL KOMMANDITGESELLSCHAFT) 7 September 1990 see page 9, line 9	1-6,8, 10,12-21
Y	see page 9, line 16 - line 23 see page 12, line 11 - line 18 see page 13, line 1 - line 9 see page 14, line 24 - line 28; claims 1-3,7-9	11
Y	EP,A,0 233 774 (DIVERSEY CORPORATION) 26 August 1987	11
A	see page 2, line 45 - line 60 see page 5, line 55 - page 6, line 10	1-3,7-9, 12-14
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	-/--	
<p><sup>9</sup> Special categories of cited documents: <sup>10</sup></p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"A" document member of the same patent family</p>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search	Date of Mailing of this International Search Report	
20 MARCH 1992	03 APR 1992	
International Searching Authority	Signature of Authorized Officer	
EUROPEAN PATENT OFFICE	HILGENGA K. J.	



III. DOCUMENTS CONSIDERED TO BE RELEVANT (CONTINUED FROM THE SECOND SHEET)		
Category *	Citation of Document, with indication, where appropriate, of the relevant passages	Relevant to Claim No.
A	EP,A,0 372 628 (AKZO N.V.) 13 June 1990  see page 2, line 35 - line 53 see page 3, line 45 - line 46 see page 4, line 14 - line 16 see page 4, line 31 - line 32 ---	1,2,4-6, 8,10,12, 13,15-21
A	US,A,4 929 375 (C.E ROSSIO) 29 May 1990 cited in the application ---	

**ANNEX TO THE INTERNATIONAL SEARCH REPORT**  
**ON INTERNATIONAL PATENT APPLICATION NO. US 9106997**  
**SA 54611**

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report.  
The members are as contained in the European Patent Office EDP file on  
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Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO-A-9010053	07-09-90	DE-A- 3905548 AU-A- 5091990 EP-A- 0384282	06-09-90 26-09-90 29-08-90
EP-A-0233774	26-08-87	AU-B- 597028 AU-A- 6901687 US-A- 4895668	24-05-90 20-08-87 23-01-90
EP-A-0372628	13-06-90	AU-A- 4589689 CA-A- 2004544 JP-A- 2194096 US-A- 5062978	07-06-90 05-06-90 31-07-90 05-11-91
US-A-4929375	29-05-90	US-A- 5009801 US-A- 5073280	23-04-91 17-12-91

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For more details about this annex : see Official Journal of the European Patent Office, No. 12/82